

## Work Order ID 83909

\*83909\*

Page 1

April-27-12 11:17:49 AM

Item ID: D3826-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib / Gusset Assembly

Start Date: 27/04/2012 Start Qty: 2.00

\*2\* 4  
\*2\* 4

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/04/27

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M114509

12.05.16. (4)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

4x 4 Cpl 12.05.17

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

S 12/05/17

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83909

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\*83909\*

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Item ID: D3826-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Rib / Gusset Assembly  
 Start Date: 27/04/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 11/05/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
*130*									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

12/5/17 *[Signature]*  
 MC 12/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 11:17:53 AM

Page 1

Work Order ID: 83909

\*83909\*

Parent Item: D3826-041

\*D3826-041\*

Parent Item Name: Rib / Gusset Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2235-1		Manufactured	No			100	Each	19.0000	1	2			
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\*D2235-1\*

Basket Rib

\*\*

12.05.16

Location

Loc Qty

Loc Code

WA

14

78636

5

81910

9

WA005

5

66895

4

79153

1

D3929-041

Manufactured

No

100

Each

11.0000

1

2

\*D3929-041\*

Gusset Assembly

\*\*

12.05.16

Location

Loc Qty

Loc Code

WA005

11

77675

2

79152

8

81255

1

D3929-042

Manufactured

No

100

Each

13.0000

1

2

\*D3929-042\*

Gusset Assembly

\*\*

12.05.16

Location

Loc Qty

Loc Code

WA005

13

77677

4

79154

8

81254

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

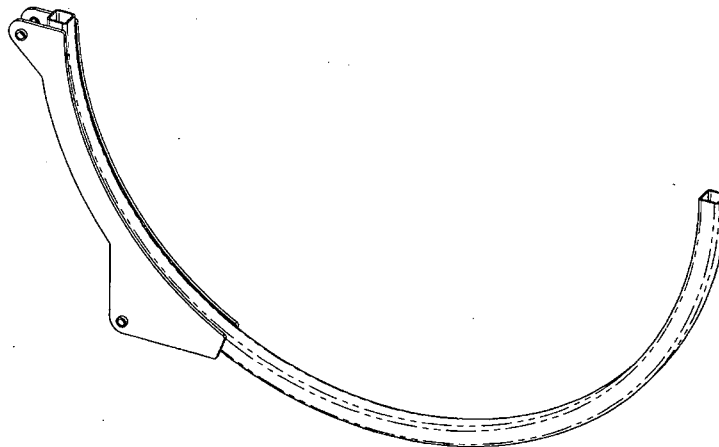
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



**D3826-041 RIB/GUSSET ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 03909 MLCJ

12/04/27

**RELEASED**  
8/10/12

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.04.16		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3826</b> REV. B <b>RIB/GUSSET ASSY</b> SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 3.32 lbs

B D3929-042  
GUSSET ASSEMBLY

B D3929-041  
GUSSET ASSEMBLY

TYP

0.250

D2235-1  
RIB

**D3826-041 RIB/GUSSET ASSY**

03909

**RELEASED**  
9/24/2014

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	